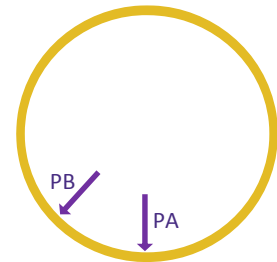


## Applications

- Applicable for the welding of 25%Cr duplex stainless steels, such as 2507.

## Features

- Service temperature up to 250°C
- High resistance to pitting corrosion and embrittlement.
- PREN 41
- Easy to remove slag
- Good bead appearance



## Typical Chemical Properties of All-Weld Metal (%)

C	Si	Mn	Cr	Ni	Mo	N
0.019	0.58	0.53	25.17	8.9	3.9	0.22

## Typical Mechanical Properties of All-Weld Metal

TS MPa	EL (%)	Temp (°C)	CVN-Impact Value (J)
830	28.0	-20	35

Diameter mm (in)	2.0 (5/64)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm (in)	300 (12)	350 (14)	350 (14)	350 (14)	350 (14)
F & HF	25-55	50-85	70-115	95-145	135-180
V-up, OH	20-50	45-80	65-110	85-135	

## Current

AC or DC ±

## Redrying Condition

350°C (662°F) x 1hr

## Packing Details

2Kg Vacuum Packing & 10Kg Ctn